

Work Order ID 58819

Wednesday, May 19, 2010 10:42:32 AM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 5/19/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10519

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3536	Rev A

100



FLOW WATER JET

Waterjet

Memo

0.00

B10-5-20

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

(12)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

FB10-5-20

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

S10/05/21

(412)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 58819

Wednesday, May 19, 2010 10:42:32 AM



Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

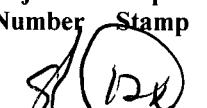
Sequence ID/
Work Center ID

130

Operation
DescriptionIdentify as per dwg & Stock Location: FP11Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

10-5-21



Packaging

Packaging

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/05/2010

MF
10-5-20

Memo

0.00

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 10:42:36 AM

Page 1

Work Order ID: 58819



Parent Item: D3536-23



Parent Item Name: Gasket

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MNEO60S.063



Purchased

No

100

sf

539.2531

1.3365

17.



HB 10-5-20

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code
MAT	400	
114691	400	
MAT052	139.2531	
114176	139.2531	114176

12

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58819
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85 *				
48.20	+/-0.030	48.20 *				
44.70	+/-0.030	44.70 *				
39.31	+/-0.030	39.31 *				
33.92	+/-0.030	33.92 *				
28.53	+/-0.030	28.53 *				
23.14	+/-0.030	23.14 *				
17.75	+/-0.030	17.75 *				
14.25	+/-0.030	14.25 *				
9.50	+/-0.030	9.50 *				
4.75	+/-0.030	4.75 *				
8.00	+/-0.030	8.00 *				
16.00	+/-0.030	16.00 *				
24.00	+/-0.030	24.00 *				
32.00	+/-0.030	32.00 *				
39.00	+/-0.030	39.00 *				
48.00	+/-0.030	48.00 *				
0.30	+/-0.030	-304 *				
0.30	+/-0.030	-301 *				
1.89	+/-0.030	1.888 *				
Ø0.19	+0.005/-0.001	.191 *				

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-5-20	Date:	10-5-20	Date:	N/A

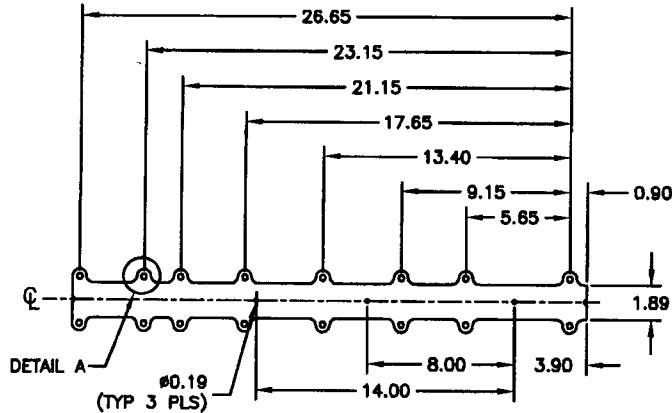
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	JL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



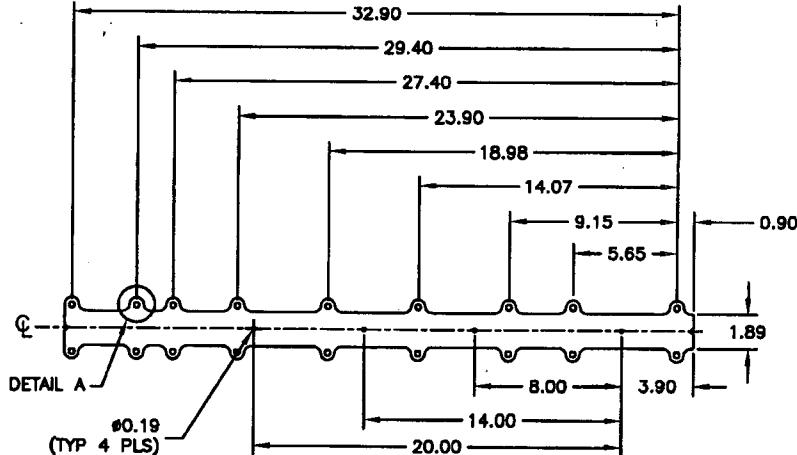
D3536-11 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S-063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58819
By 10-5-19

09-02-12
RELEASED



D3536-13 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	C8	PORT HADLOCK, WA
06.10.25	PH	DRAWING NO. D3536
A	06.10.25	DATE TITLE GASKET
		REV. A SHEET 1 OF 6 SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

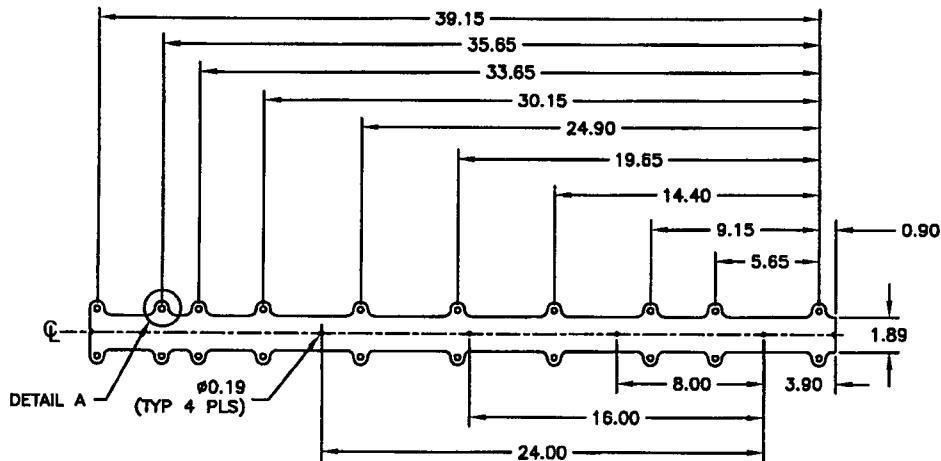
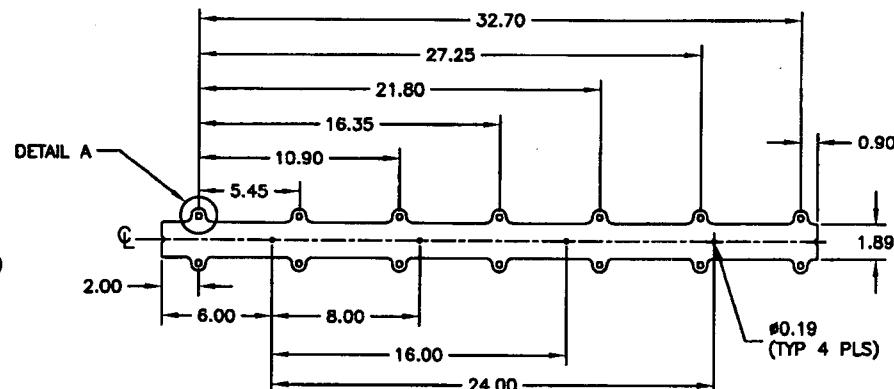
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
		REV. A SHEET 2 OF 6 SCALE 1:10

RELEASER
07.02.12

W/0 38819

**D3536-15 GASKET****D3536-21 GASKET****NOTES**

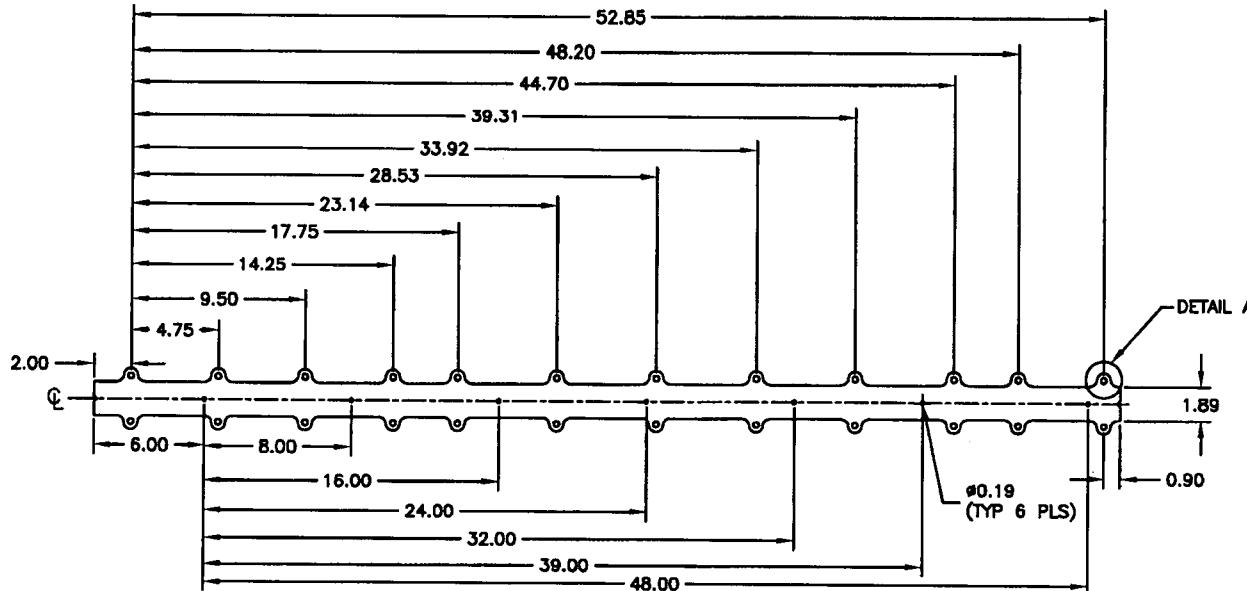
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

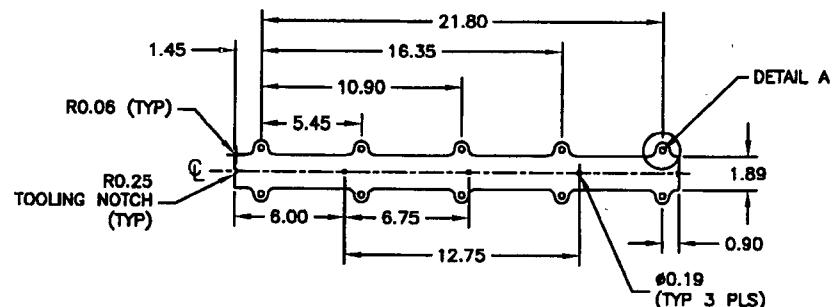
NOTE: Date & initial all entries



D3536-23 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
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D3536-25 GASKET

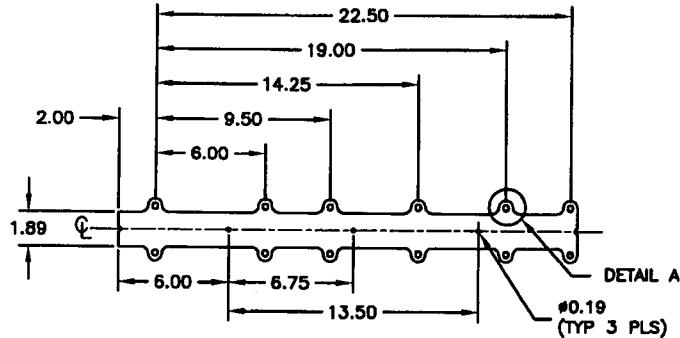
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C8	C8	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE		REV. A
06.10.25		SHEET 3 OF 6
		SCALE
		1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

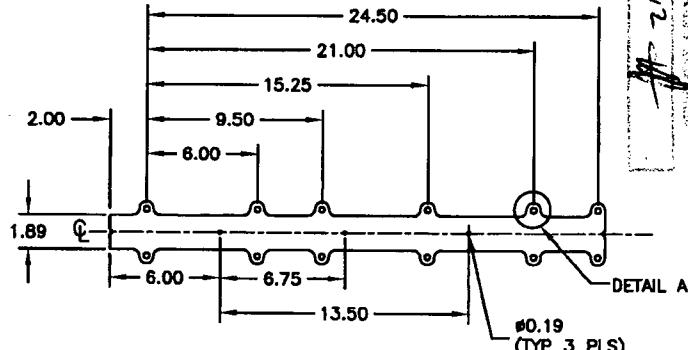
NOTE: Date & initial all entries



D3536-31 GASKET

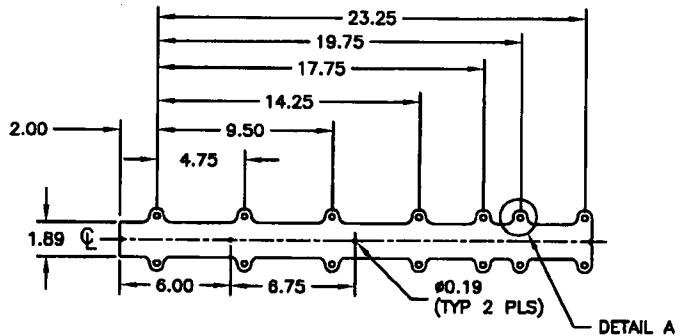
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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D3536-33 GASKET

W/0 58819



D3536-35 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PART HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE		TITLE
06.10.25		GASKET
SCALE		REV. A
1:10		SHEET 4 OF 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

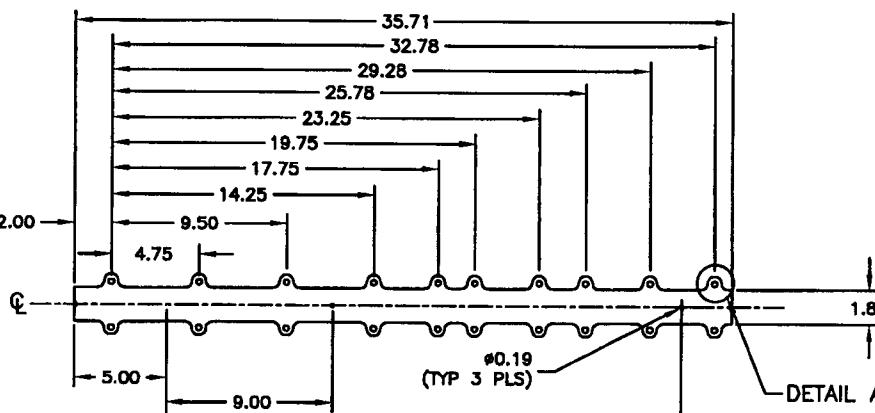
NOTE: Date & initial all entries

DART

DESIGN C.B	DRAWN BY C.B	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 5 OF 6 SCALE 1:10

07.02.02 *CH*

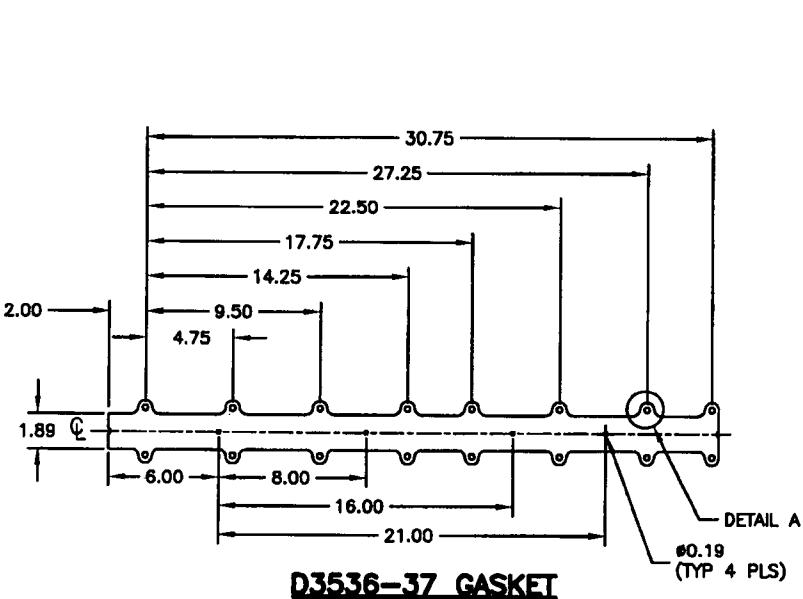
w/o 58819



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
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D3536-37 GASKET

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

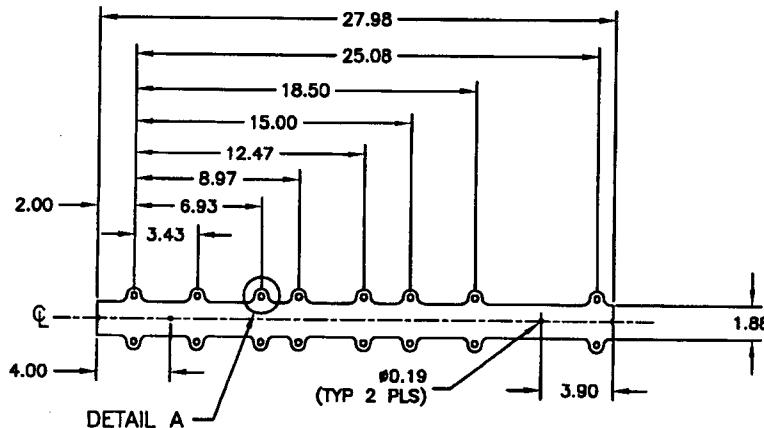
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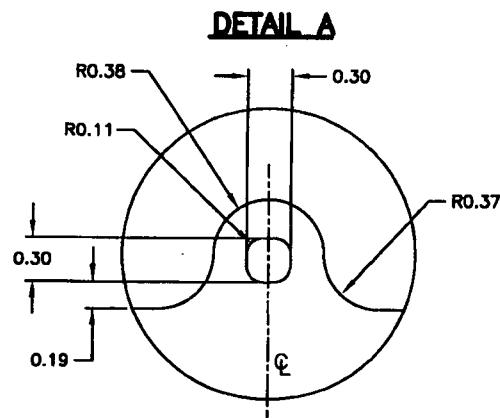
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DESIGN C.B	DRAWN BY C.B	DART AEROSPACE USA, INC. PORT HADLOCK, WA.
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 6 OF 6 SCALE 1:10

07.02.12 *PH*

**D3536-41 GASKET**

w/o 58819



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